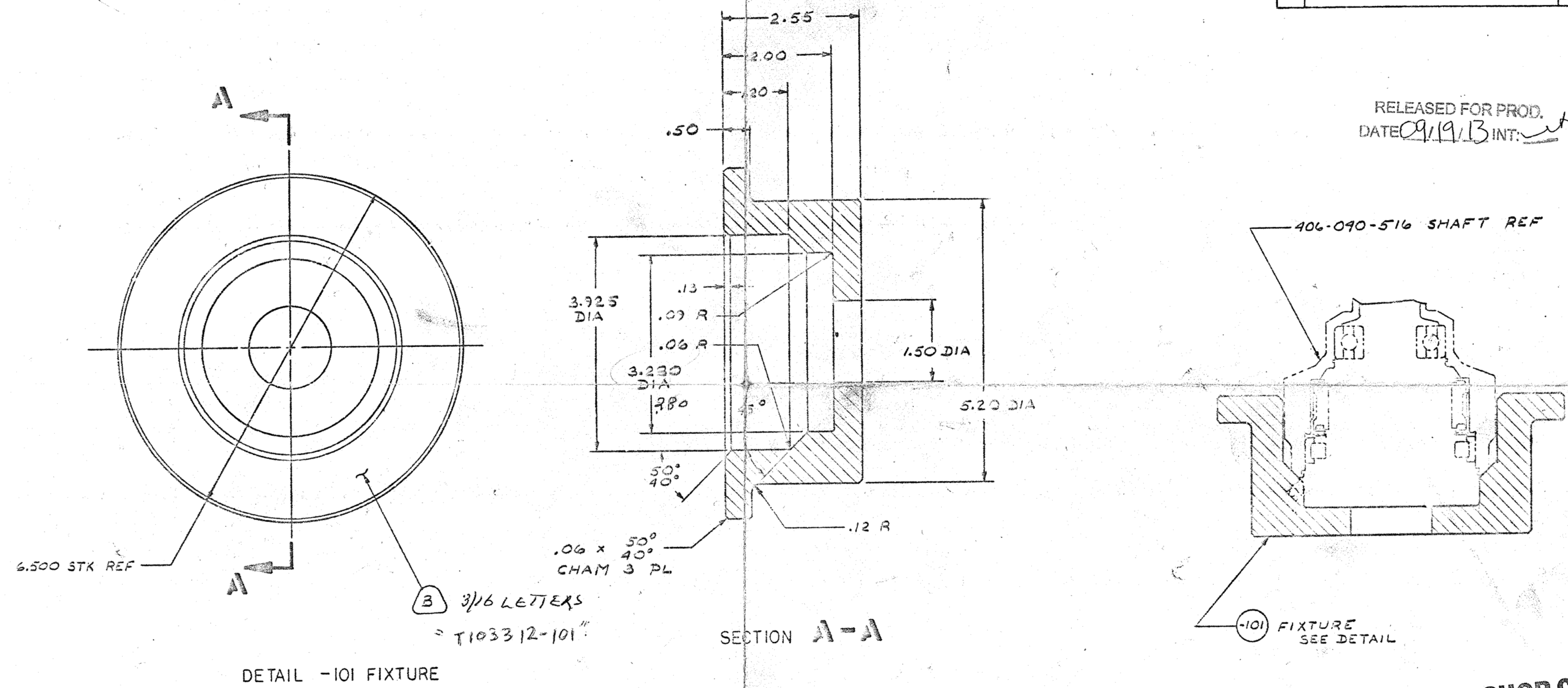


REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

RELEASED FOR PROD.
DATE 09/19/13 INT: *[Signature]*



SHOP COPY

WVA: 406D2.26 WOI: 4907 MAT 2024-6061

SEE SEPARATE PARTS LIST

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THE FOREGOING DOES NOT APPLY TO VENDOR PARTS		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS XXX ± .03 X ± .1 ANGLES ± 1/2°	
DASH NO. NEXT ASSY USED ON APPLICATION		SURFACE ROUGHNESS PER ANSI 14.1 125 MACHINED SURFACES EXCEPT AS NOTED	

Bell Helicopter Textron TITLE FIXTURE, DISASSEMBLY- OUTER SHAFT FREEWHEELING ASSY	
DWG CODE IDENT NO D 97499	DWG NO T103312
SCALE 1/1	SHEET 1 OF 1

PARTS LIST	Bell Helicopter TEXTRON POST OFFICE BOX 432 • FORT WORTH, TEXAS 76101	CODE IDENT NUMBER	CONTRACT NUMBER	HEAT TREAT SPEC	NUMBER	REVISION LETTER
		97499	FOR INTERPRETATION SEE 299 - 947 - 739	FINISH SPEC	PLT103312	-
DRAWING TITLE				EWA	DRAWING TYPE	
FIXTURE, DISASSEMBLY - OUTER SHAFT, FREEWHEELING ASSY				4060225	T	SH 1 OF 1
PL REVISION RECORD						
LTR	DESCRIPTION	DATE	LTR	DESCRIPTION	DATE	LTR
	ORIG RELEASE	10-13-82				
PL NOTES						
LTR LINE NOTE						
A	1	BREAK ALL SHARP EDGES .015 R OR .015 X 40-50 DEGREES.				
B	1	MARK PART NO. ON INDICATED SURFACE PER SPS 4050 USING STEEL STAMP WITH .13 HIGH FIGURES.				
C	1	ANODIZE PER MIL-A-8625 TYPE II, CLASS 1.				
D	1	THIS TOOL IS USED TO REMOVE THE BEARINGS AND CLUTCH FROM INSIDE THE 406-040-516 SHAFT.				
E	1	TO DISASSEMBLE THE SHAFT, REMOVE THE RETAINING RING, WASHER, SHIM AND ANTI-ROTATION RING FROM				
	2	IN FRONT OF THE ROLLER BRG. PLACE SHAFT IN FIXTURE AS SHOWN. GRASP RIM OF FIXTURE AND BOUNCE				
	3	ON WORKBENCH UNTIL ROLLER BRG IS REMOVED FROM SHAFT. REMOVE ROLLER BRG AND CLUTCH FROM				
	4	FIXTURE. REMOVE BALL BRG RETAINING RING AND PLACE SHAFT BACK IN FIXTURE AND BOUNCE UNTIL BALL				
	5	BRG IS REMOVED.				
F		FINAL HEAT TREAT CONDITION MUST BE AS SPECIFIED FOR STARTING MATERIAL.				
PART NUMBER MATERIAL REQUIREMENTS						
DASH	***** STOCK SIZE *****	***** TNSL 1000 PSI OR COND *****	***** MATERIAL *****			
NO	NOMENCLATURE	THICKNESS/SHAPE	WIDTH/WALL LENGTH	INITIAL	FINAL	SPECIFICATION
-101	FIXTURE	6.5000 DIA	2.6	T351	T351	2024 AL ALY QQ-A-225/0
PARTS LIST						
RV *****	QUANTITY PER ASSEMBLY *****	PART NUMBER	NOMENCLATURE	EFFECTIVITY CODE	FINISH	C.
LR				GFAE FROM	THRU IDENT	CHEN DRG NOTE
		-101	FIXTURE			NOTE
END PARTS LIST						

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THE FOREGOING DOES NOT APPLY TO VENDOR PARTS.

FORM 7840 - 69759